

Work Order ID 73712

Wednesday, September 14, 2011 9:15:10 AM



Page 1

Item ID: D412-698-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Automatic Door Opener, LH/RH

Start Date: 9/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/09/14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

5/11/12/20

11-9-19

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/9/19

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5/11/12/20

11/9/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 9/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-023

Location: 10PPP Rev: B

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/9/2011

MF
11-09-20

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 73712

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 9/14/2011

Required Date: 9/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purchase	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD516L	NAS1149D0516J	Purchased	No			120	Each	12.0000	2	12			
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Washer

Location	Loc Qty	Loc Code
ST347	12	

D3552-11		Manufactured	No			120	Each	17.0000	1	6			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Door Prop

Location	Loc Qty	Loc Code
112466	12	

Location	Loc Qty	Loc Code
ST272	17	

D3594-043		Manufactured	No			120	Each	19.0000	1	6			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Floor Doubler Assembly, LH

Location	Loc Qty	Loc Code
68791	5	
72239	12	

Location	Loc Qty	Loc Code
ST234B	19	

D3594-044		Manufactured	No			120	Each	17.0000	1	6			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Floor Doubler Assembly, RH

Location	Loc Qty	Loc Code
67012	9	
71690	10	

Location	Loc Qty	Loc Code
ST234B	17	

68387	7	
71691	10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73712

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 9/14/2011

Required Date: 9/16/2011

Start Qty: 6.00

Required Qty: 6.00

D3594-5 Manufactured No

120 Each

19.0000

1

6



Door Doubler

Location

Loc Qty

Loc Code

ST234A

19

66651

1

71692

18

D3622-1 Manufactured No

120 Each

43.0000

2

12



Ball Stud

Location

Loc Qty

Loc Code

ST070

43

71540

13

72102

30

MS20426AD4-4 Purchased No

120 Each

2,011.000

2

12



Rivet

Location

Loc Qty

Loc Code

ST317

2011

116188

2011

MS21073L5 Purchased No

120 Each

90.0000

1

6



nut plate

Location

Loc Qty

Loc Code

ST302

90

117395

90

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E

Date: 08.05.01